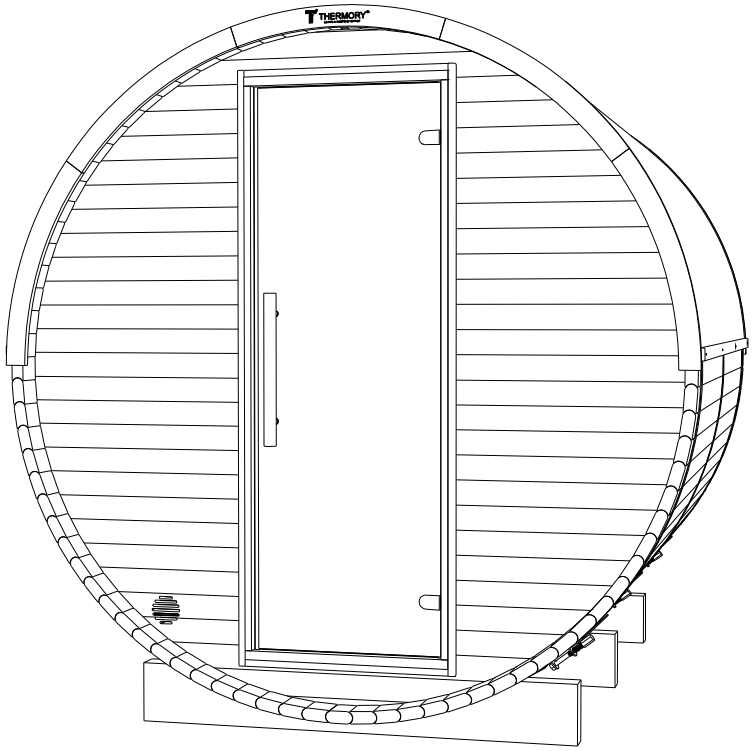
SALUS SAUNAS

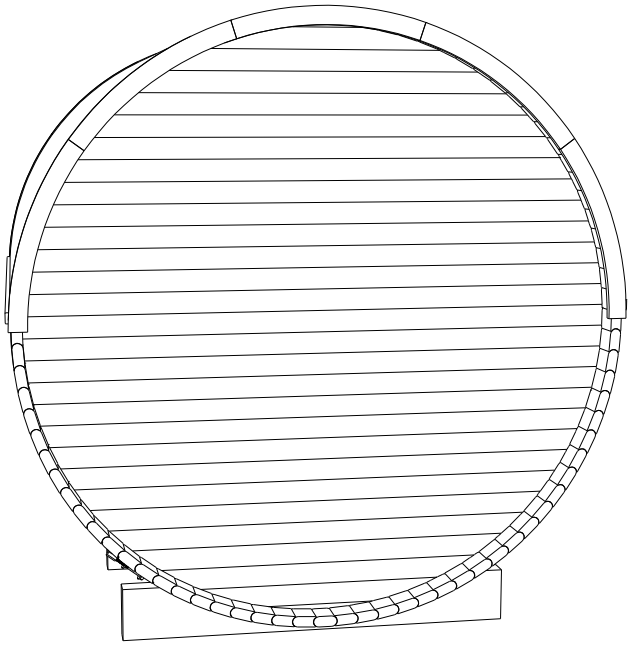
Horizon Barrel Sauna

OWNER'S MANUAL

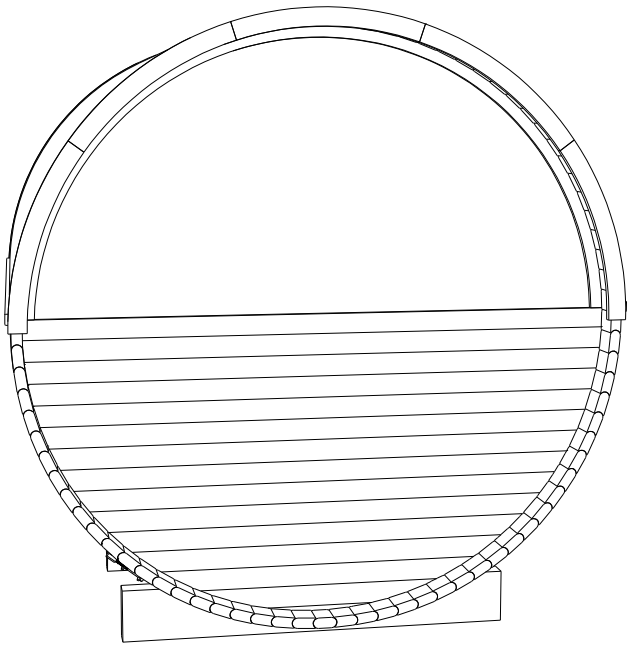
WARNING! Do not place anything combustible close to heater, above the heater, and on both sides of the heater. This includes but not limited to towels, lights, robe hookes, accessories, etc. Nothing should be on the same wall as your heater that is combustible.

BARREL SAUNA
ASSEMBLY INSTRUCTIONS





Model: No51; No53; No63



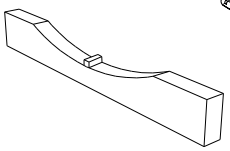
Model: No50; No52; No62

Note: Please read the manual before construction

Rev. 23.09.2024.

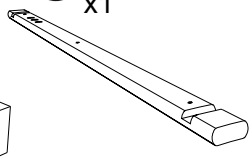
PART LIST

A x3



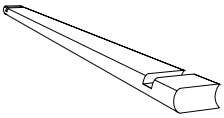
cradle

B x1



center stave

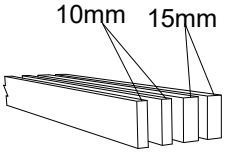
C No50s x74 | No60s x88



body stave

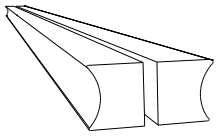
H1 x4

10mm 15mm



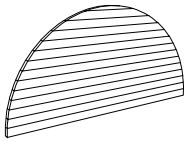
different thickness filling peaces

H x2



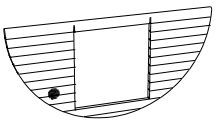
final H tipe stave at the top

V3 x1



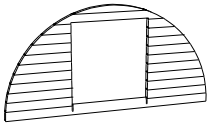
upper rear panel

F x1



front panel bottom

F1 x1

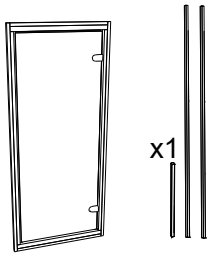


front panel top

F2 x1

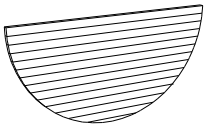
x1 x1

x1



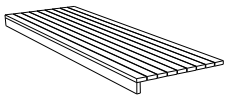
door and door moldings

V x1



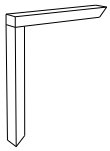
bottom rear panel

J x2



sauna bench

J1 x2

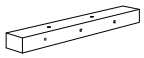


supporting leg

J2 x2

backrest

J3 x4



wall mount

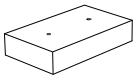
N1 x2

door handle

L x2

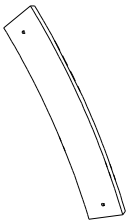
sauna floor

L1 x6



fixing block for sauna floor

W x10

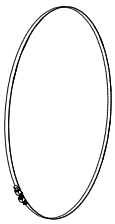


decorative roof finishing board

O x1

roof board

I x3



metal band

S1 No50s x45 | No60s x50

screw 5.0x100 SS

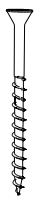
S10 No50s x135 | No60s x160

screw 4.0x60

S5 No50s x25 | No60s x50

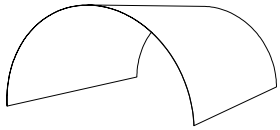
screw 4.0x50 SS

S4 x11



screw 5.0x120

Z x1



Waterproof roof cover

S6 x30

screw 5.0x70 SS

S7 x35

screw 4.2x55 brown

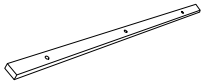
S2 x25

screw 4.0x70 SS

S14 x10

screw 5.0x80

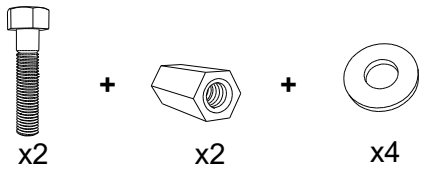
Z1 x2



Slat for roof cover

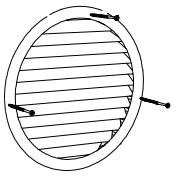
PART LIST

S9



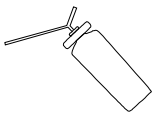
x2 bolt ⌀12x140 + x2 hex nut M12 (SW19) + x4 flat washer

Y1 x1

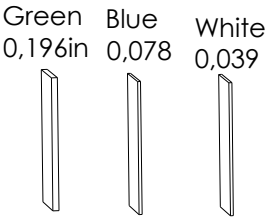


ventilation grill

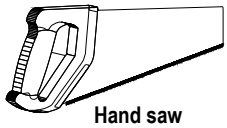
P7



Construction foam



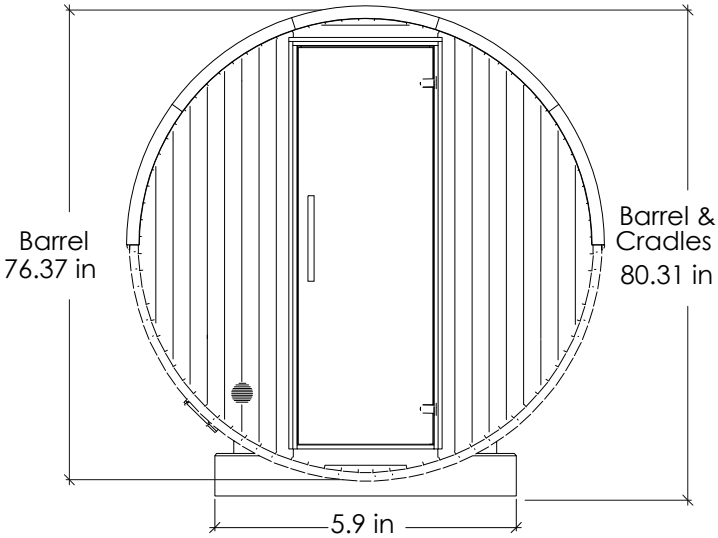
door box spacers



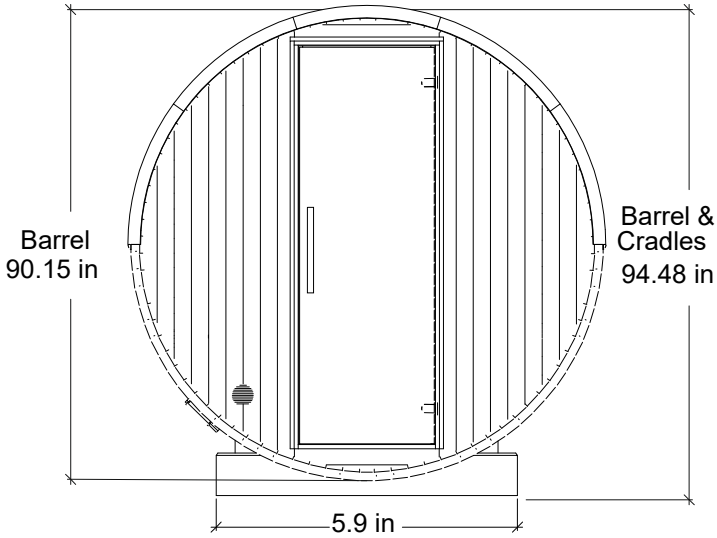
Hand saw

Barrel Dimensions

No50s



No60s



RECOMMENDATION

2 person recommended

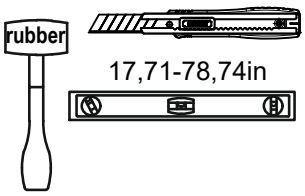
Before you begin, be sure the sauna will fit in your chosen location.

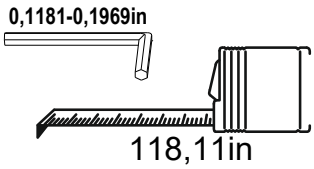
Be sure the site is level and free of standing water after rainfall.

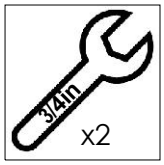
Concrete, pavers or crushed stone is preferred.

Check parts before construction.

TOOLS REQUIRED

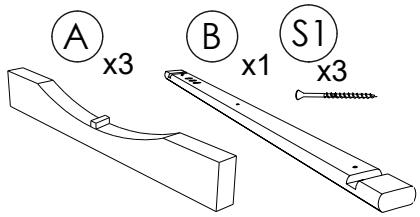


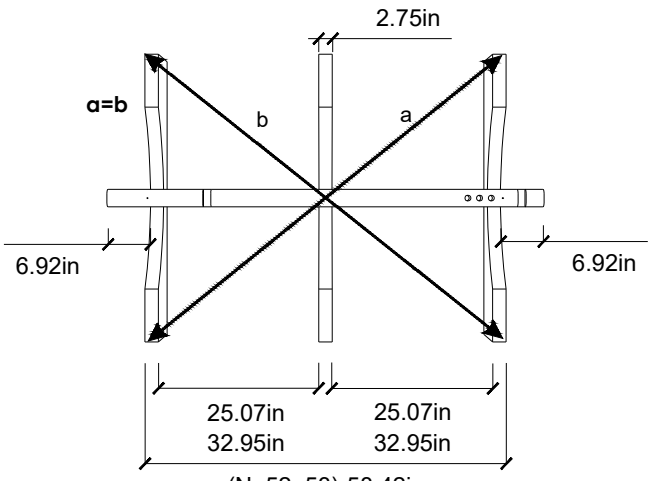




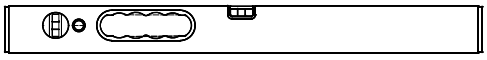
Ø 0,1575-0.3937in

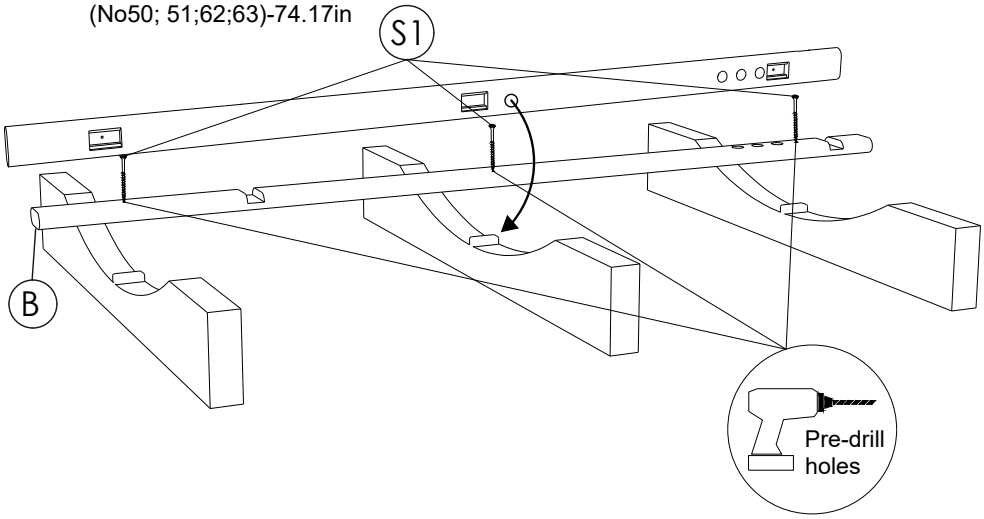
STEP 1: Measure support cradles (A) diagonally from corner to corner. Measurements “a” and “b” should be equal to ensure the cradles are square. Be sure cradles remain level. Place the support cradles (A)on level site. Carefully level for better stability. Place the center stave (B) on wooden dowels embedded in outer support cradles (A). Fix the center stave (B) with 5.0x100 SS(S1). Pre-drill holes before fix staves with screws.





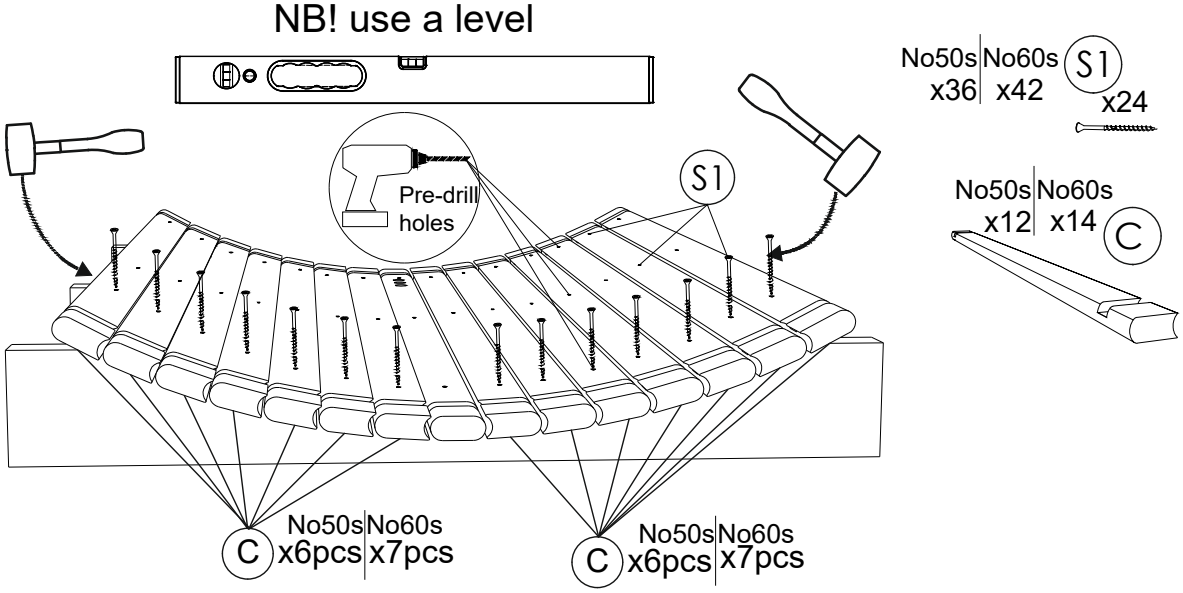
NB! use a level



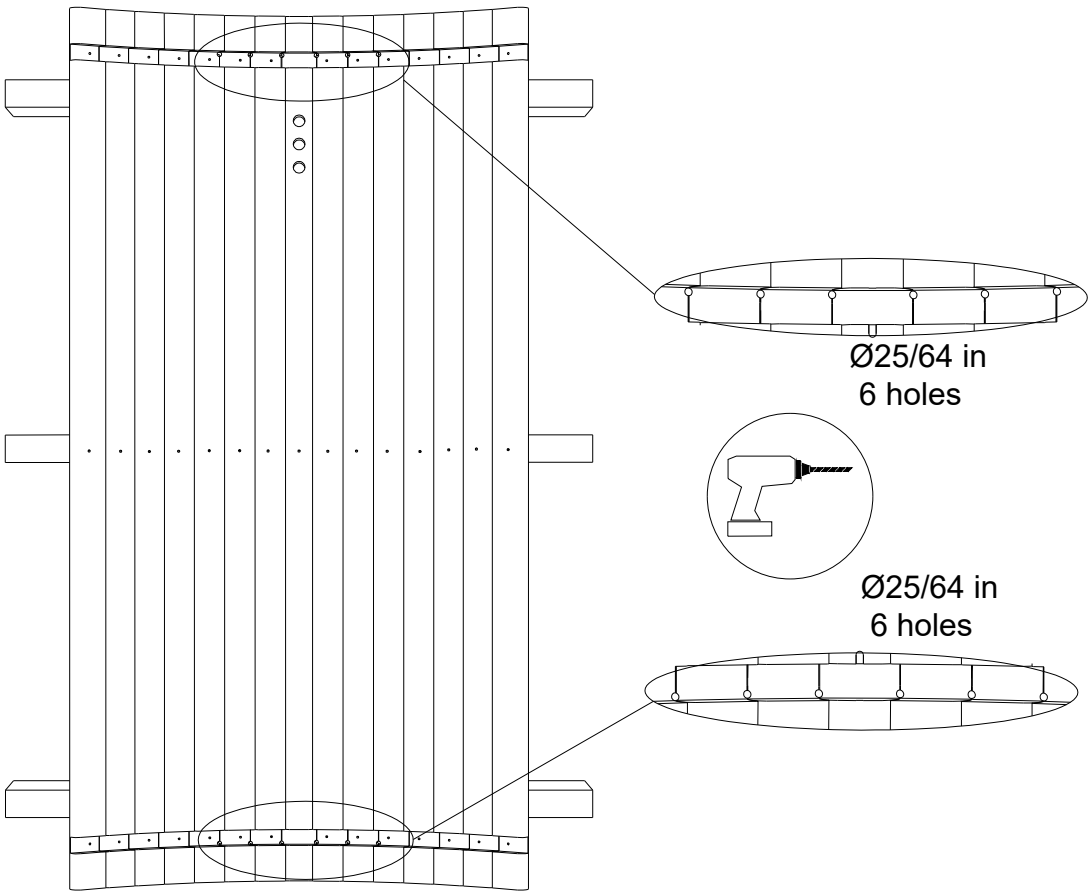


STEP 2: Pre-drill holes before fix staves with screws. Place 6 (R190) or 7 (R225) sauna body staves (C) to each side of the center stave (B)and fix with screws 5.0x100 SS (S1). Be sure to align the panel groove on every next body stave, to do that use rubber hammer.

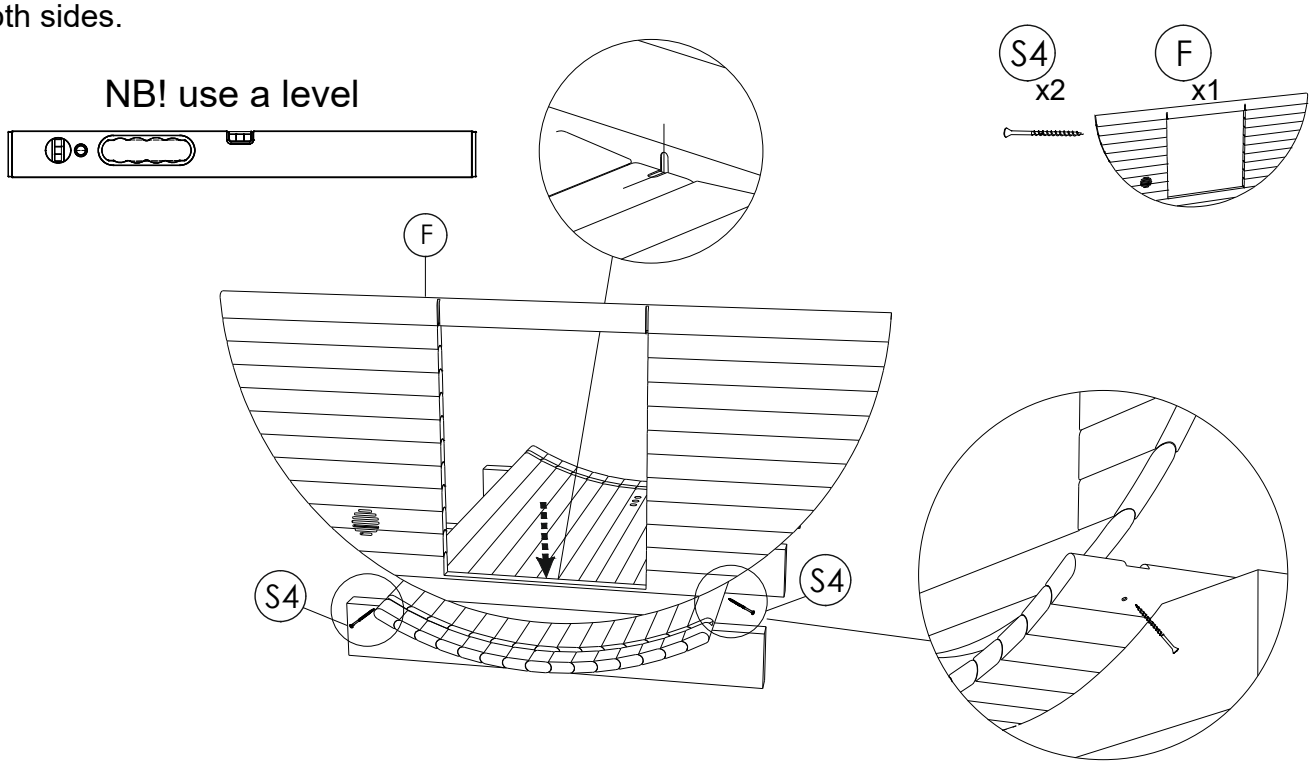
NB! use a level



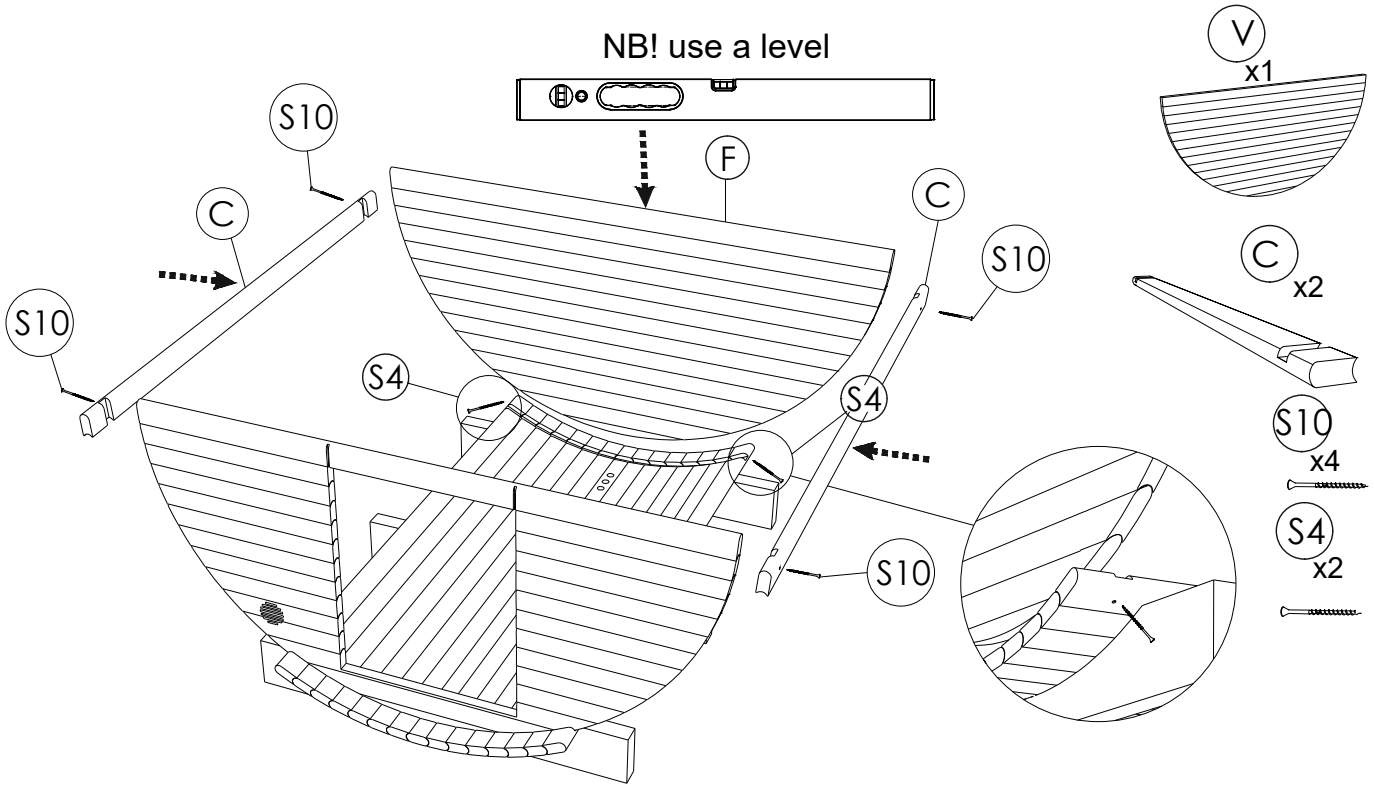
STEP3: Drill six 25/64 in holes in front and back wall groove to the out-side in board connections as shown in the picture.



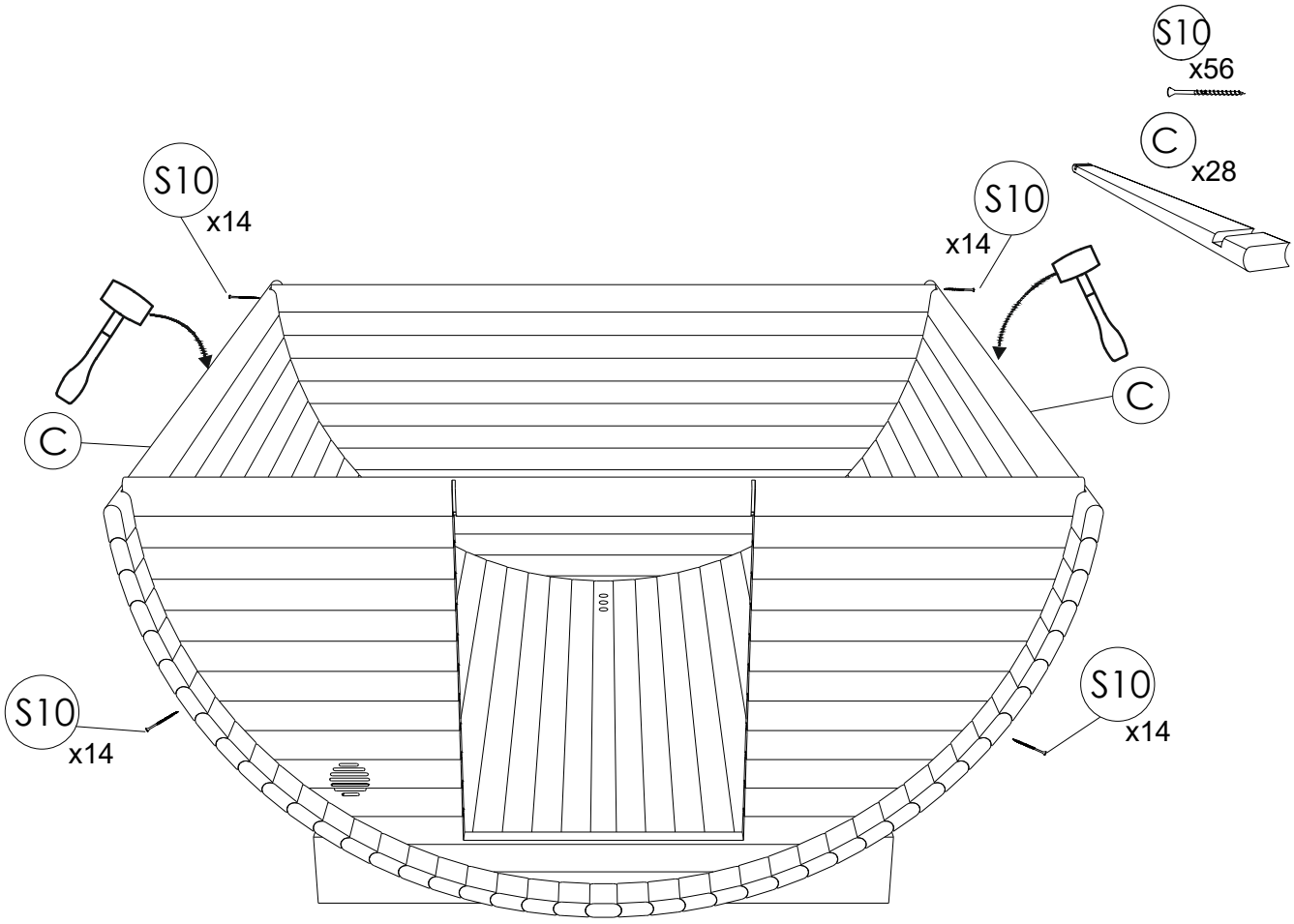
STEP 4: Place front bottom panel (F) in stave groove, be sure panel is centered, leveled,completely seated. Fix panel using 5.0 x 120 (S4) screws through last floor stave on both sides.



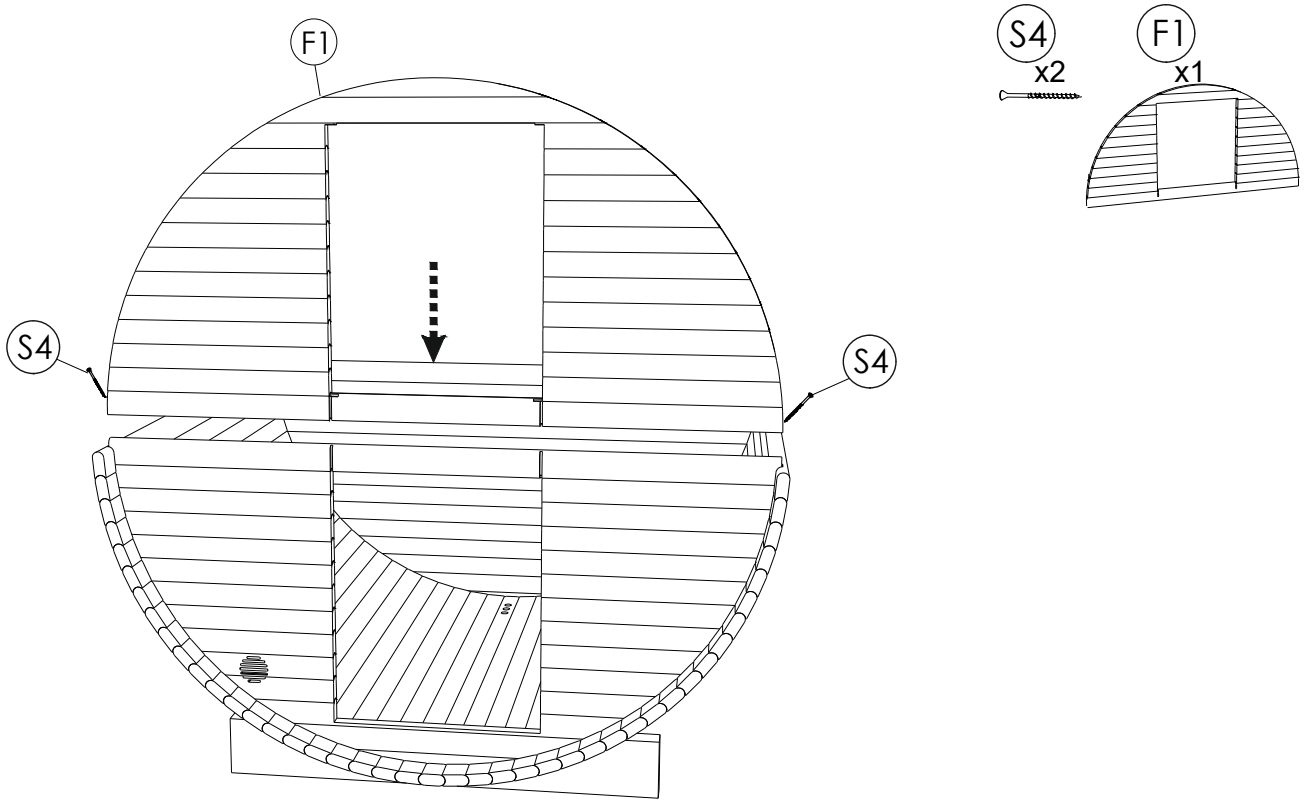
STEP 5: Place rear panel (V) in stave groove, be sure panel is centered, leveled,completely seated. Fix panel using 5.0 x 120 (S4) screws through last floor stave on both sides.



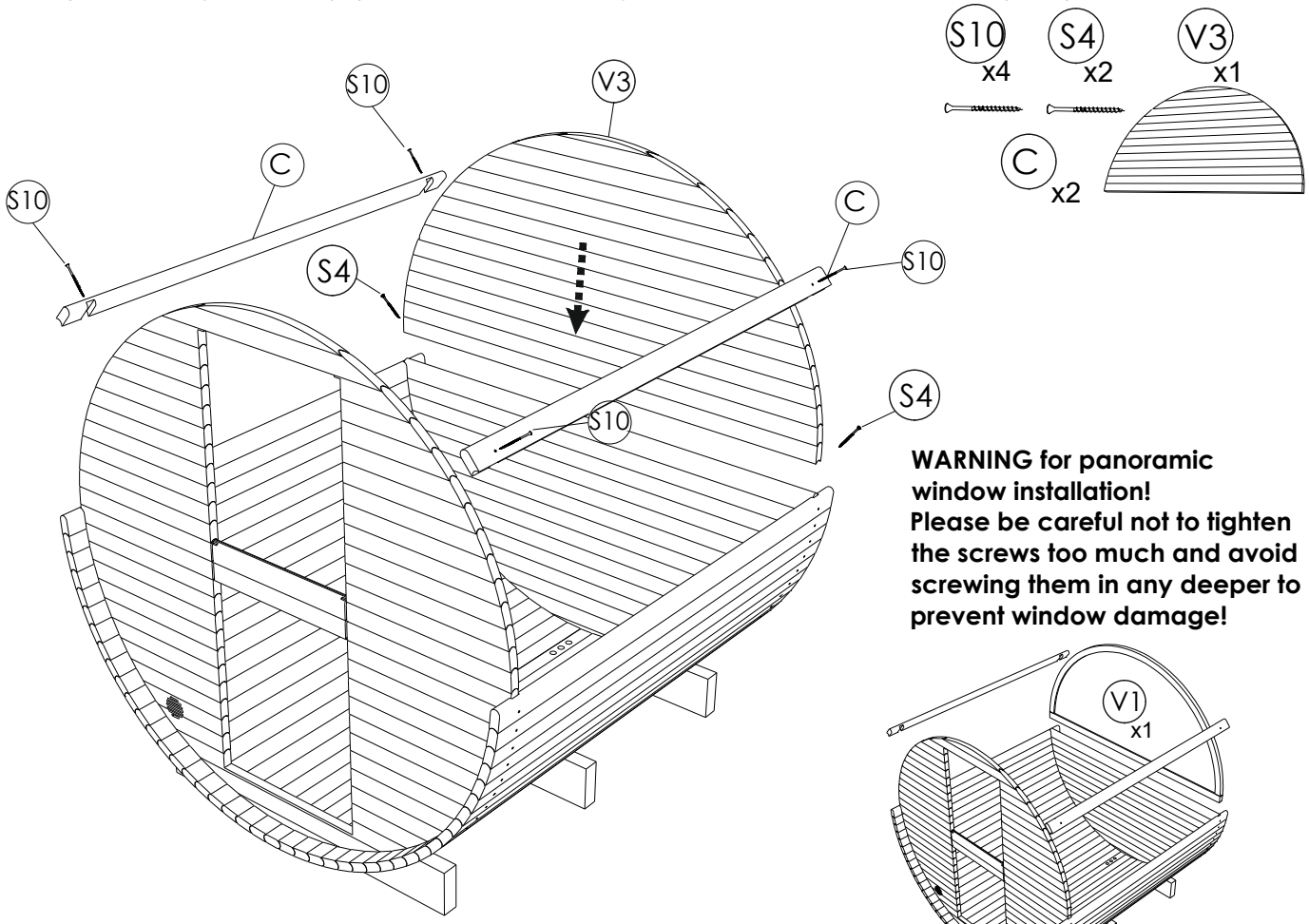
STEP 6: Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws 4.0x60(S10) . Fix one stave higher on left side than at right.



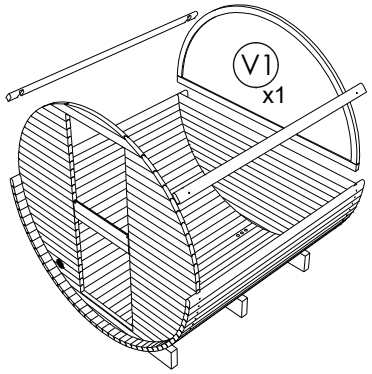
STEP 7: Place front top panel (F1) on front bottom panel (F), be sure panel is centered, leveled,completely seated. Fix panel using 5.0 x 120 (S4) screws on both sides.



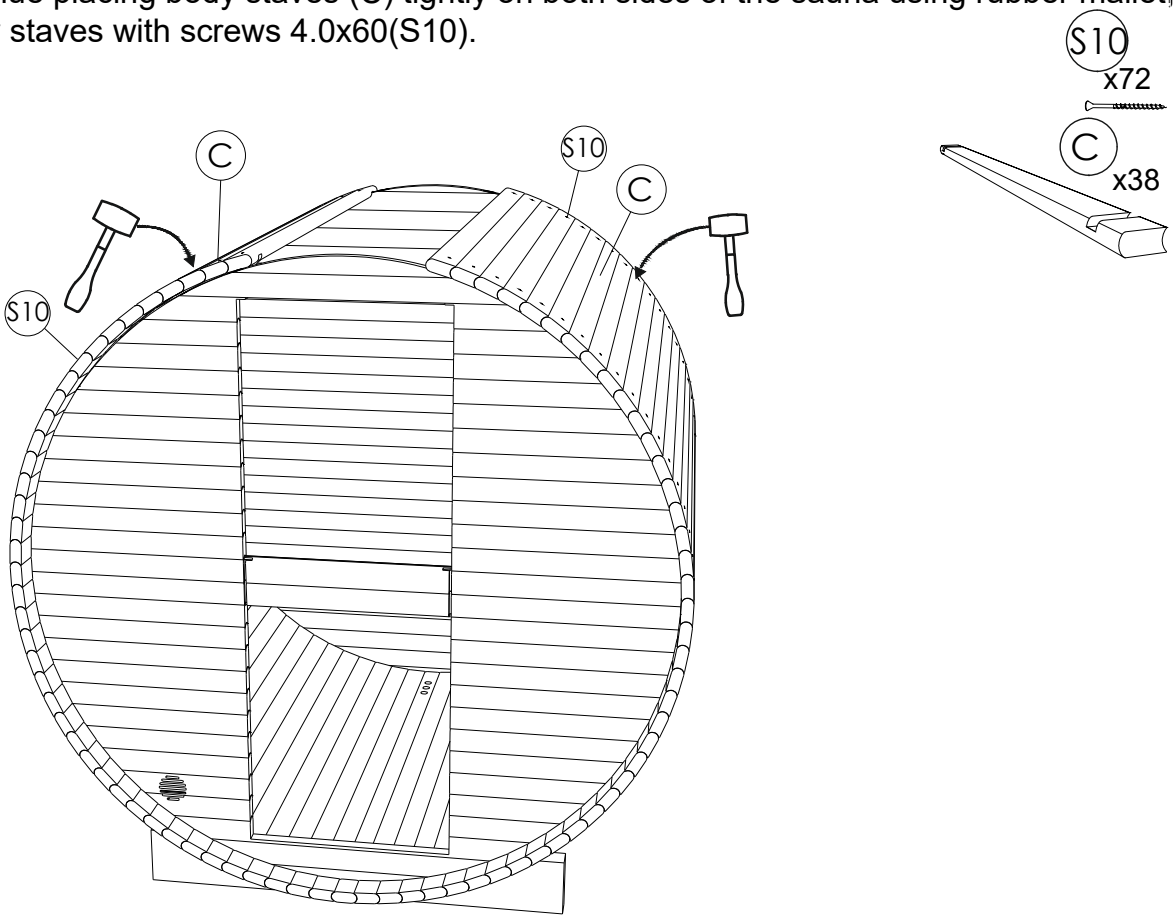
STEP 8: Take the upper rear panel (V3 or V1-panoramic window) and place it on the bottom rear panel (V). Secure it by using 2 screws 5.0 x 120 (S4). Connect the panels (F2; V3) together by placing one body staves (C) both sides where you can reach, with 4.0x60 (S10) screws.



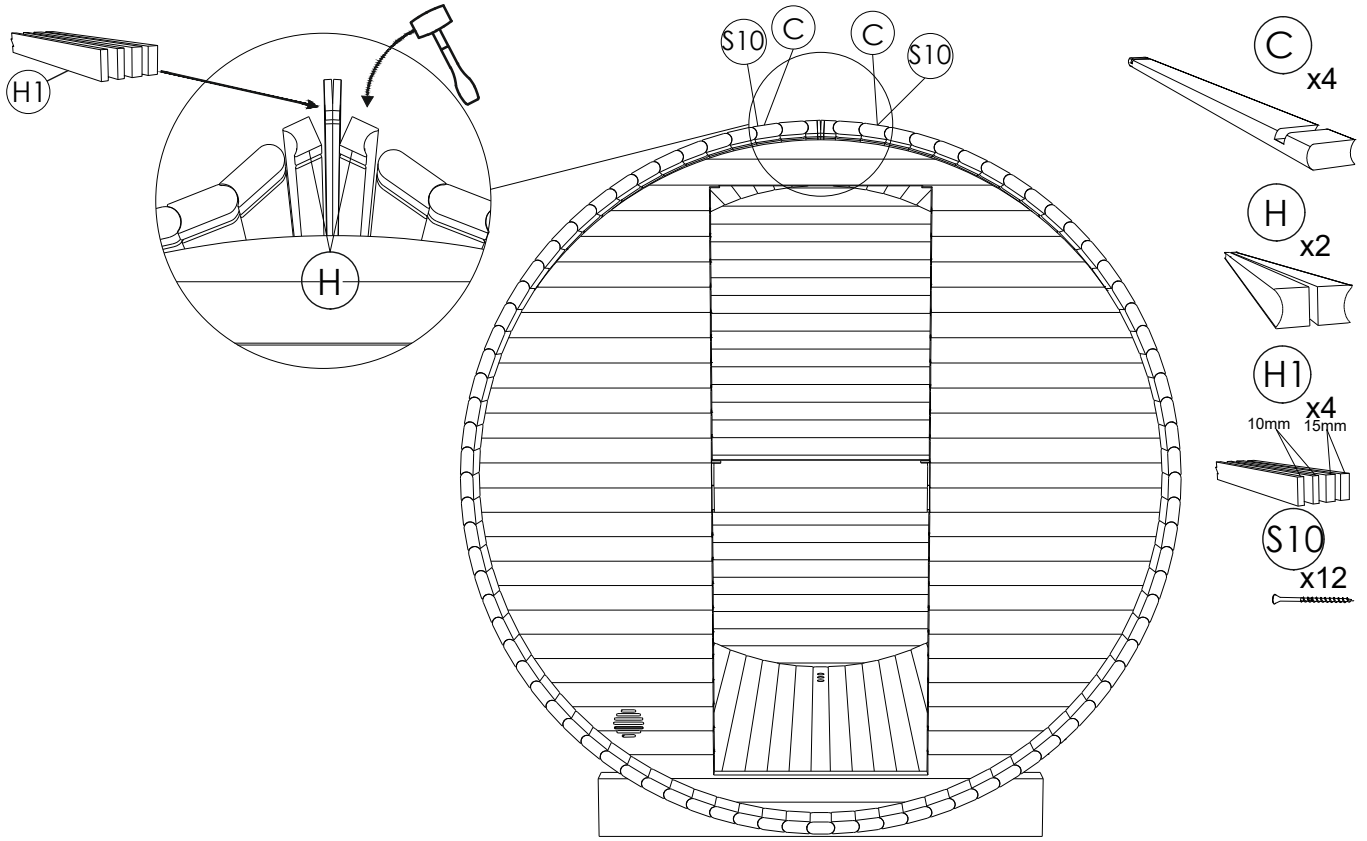
WARNING for panoramic window installation!
Please be careful not to tighten the screws too much and avoid screwing them in any deeper to prevent window damage!



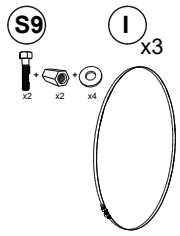
STEP 9: Continue placing body staves (C) tightly on both sides of the sauna using rubber mallet, and fixing body staves with screws 4.0x60(S10).

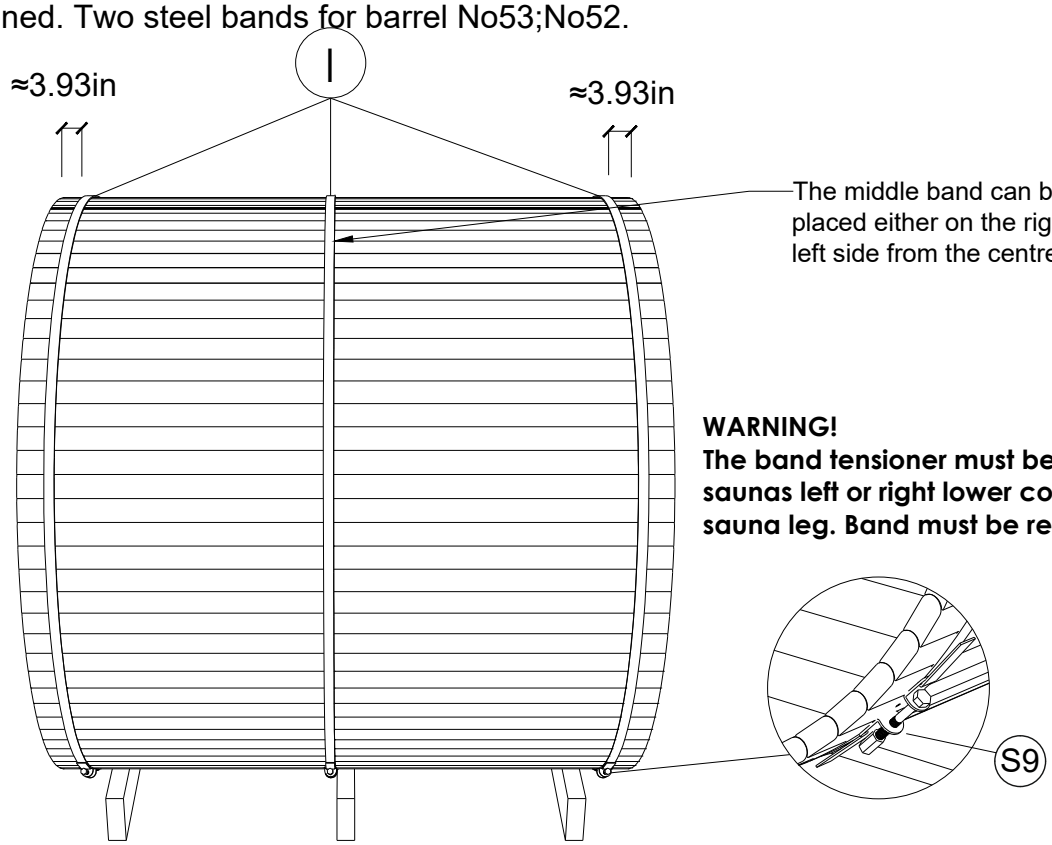


STEP 10: To finish the roof top joint, don't screw about last 2-3 boards (C) to each side, use roof finishing item (H). Different thickness filling pieces (H1) are provided to completely fill the gap. Once necessary parts are in, fix last boards with screws.



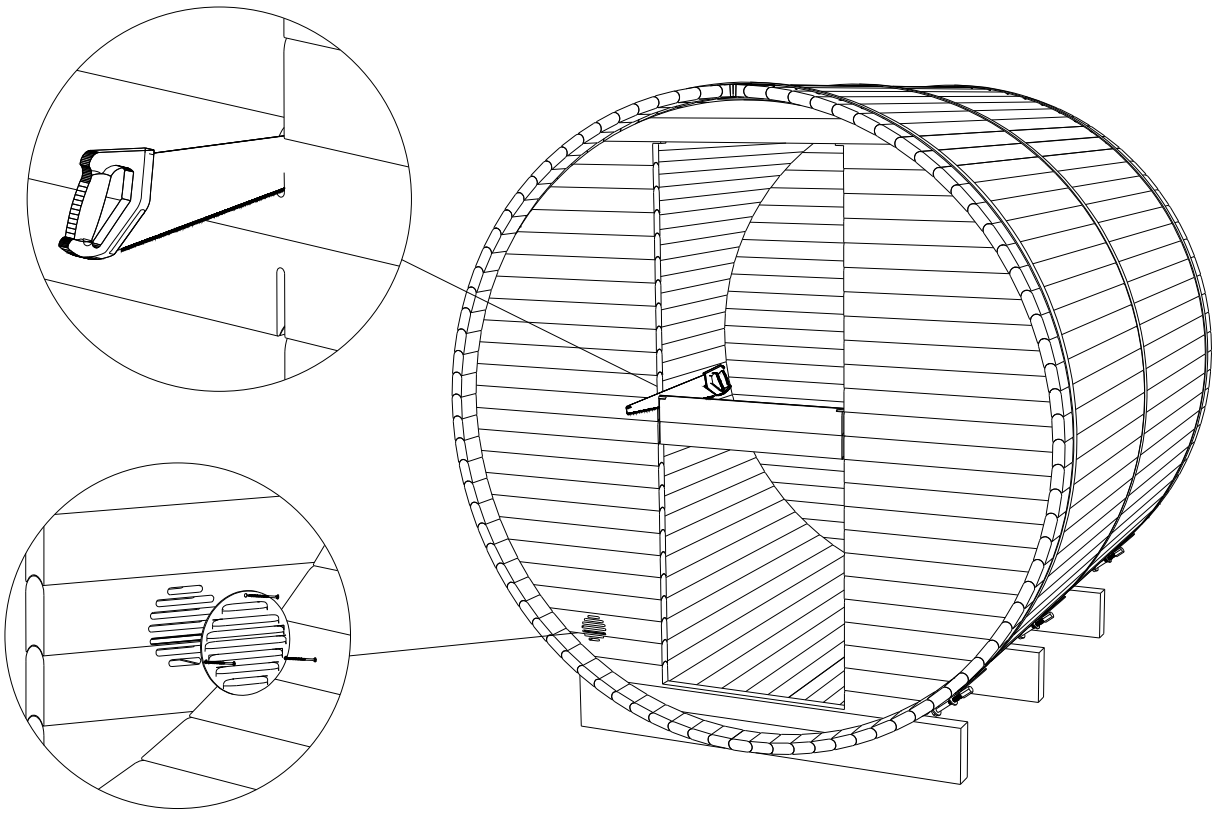
STEP 11: Install steel bands (I) by wrapping bands around the barrel, then connect with bolts and nuts (S9). Place steel bands evenly around the barrel no more than 3.93in from sauna front and back edges. Bands should cover screw heads evenly.The middle band can be placed either on the right or left side from the centre cradle. The bands should be tense, they cant be loosened. Two steel bands for barrel No53;No52.



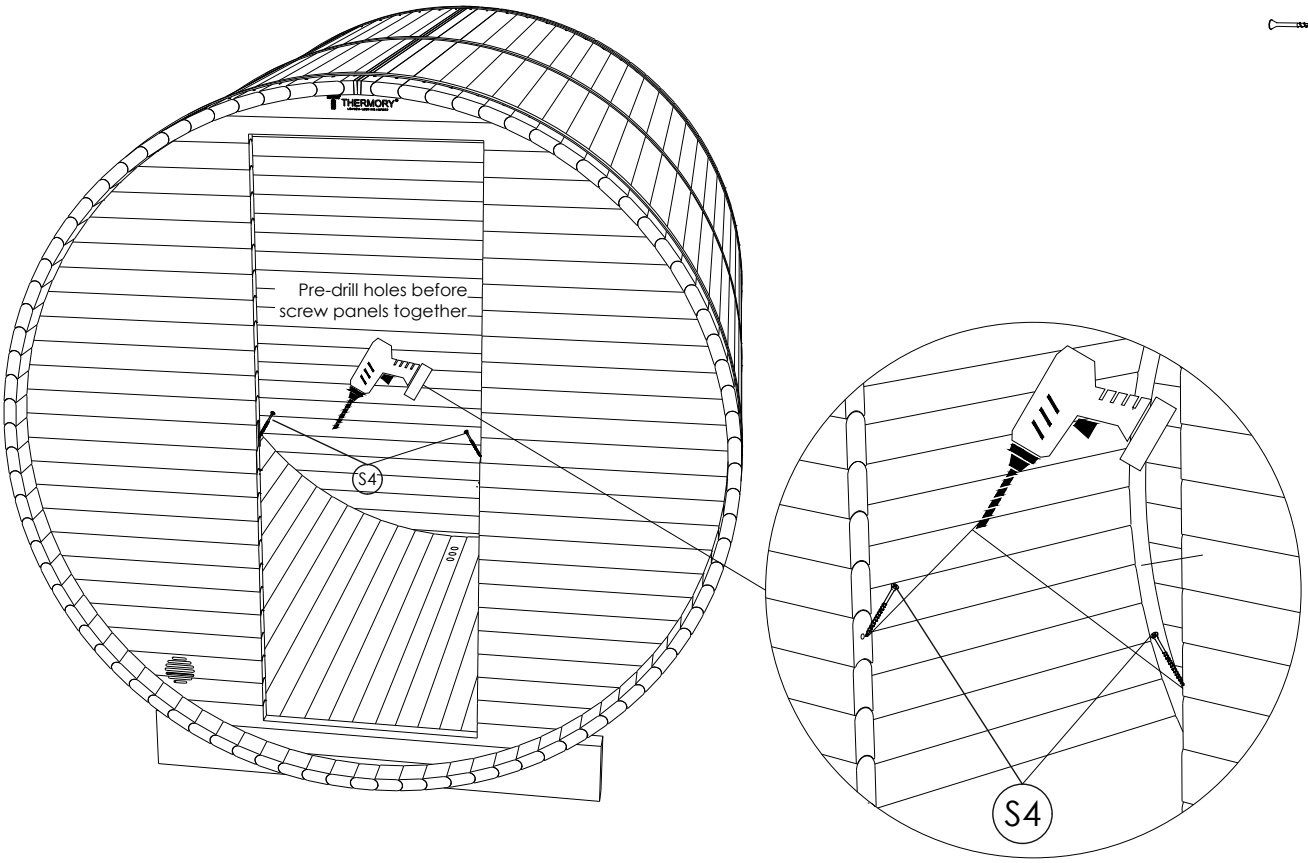


WARNING!
The band tensioner must be placed at the saunas left or right lower corner, near to the sauna leg. Band must be really tight

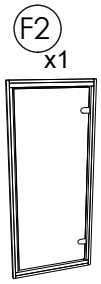
STEP 12: Draw straight line to connect both cuts. Use hand saw or other cutting machine to saw out excess boards for door box. It's recommended to saw out boards from inside. Fix ventilation grill (Y) from inside on ventilation cuts.

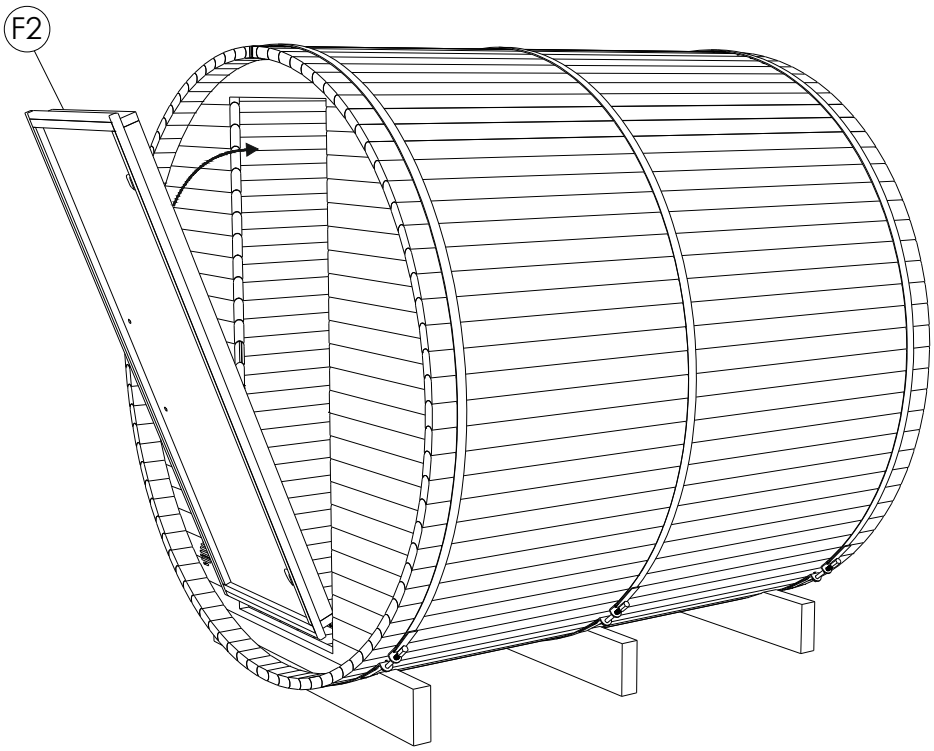


STEP 13: Pre-drill holes for screws. Fix both panels together using 5.0x120 (S4) screws.

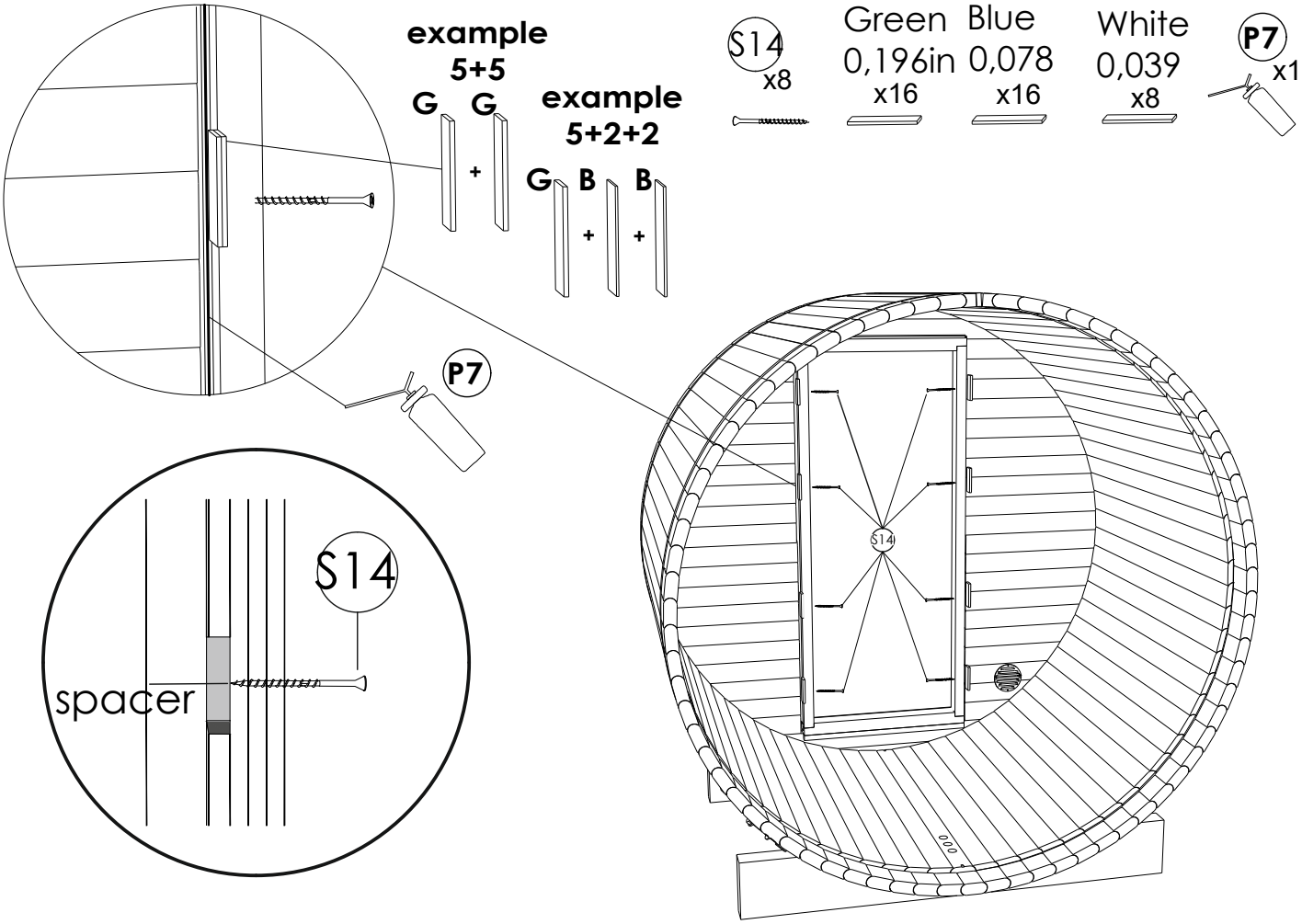


STEP 14: Install the doors (F2). Put the doors on threshold and lay in frame about in the middle. Fix doors with clamps or another person should hold the door.

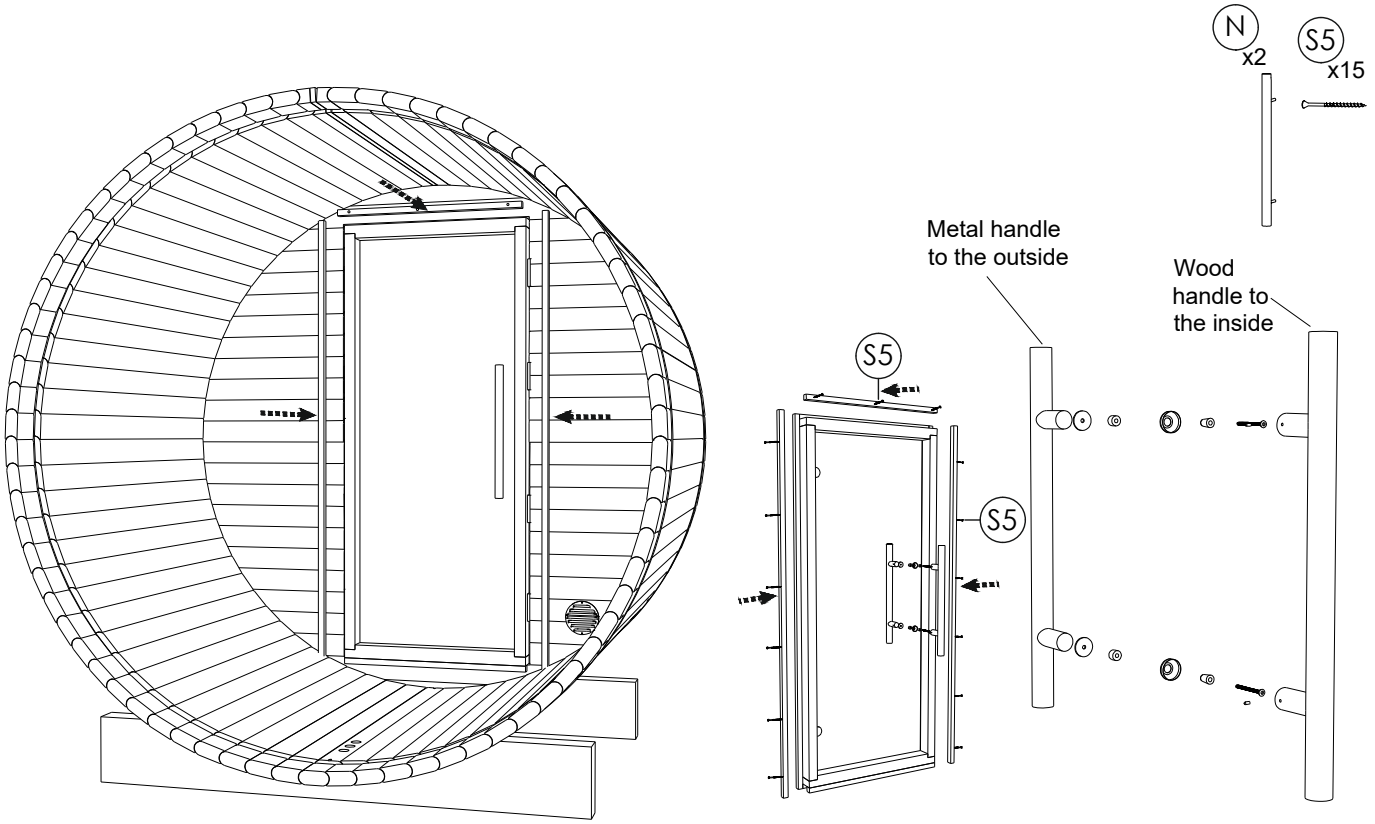




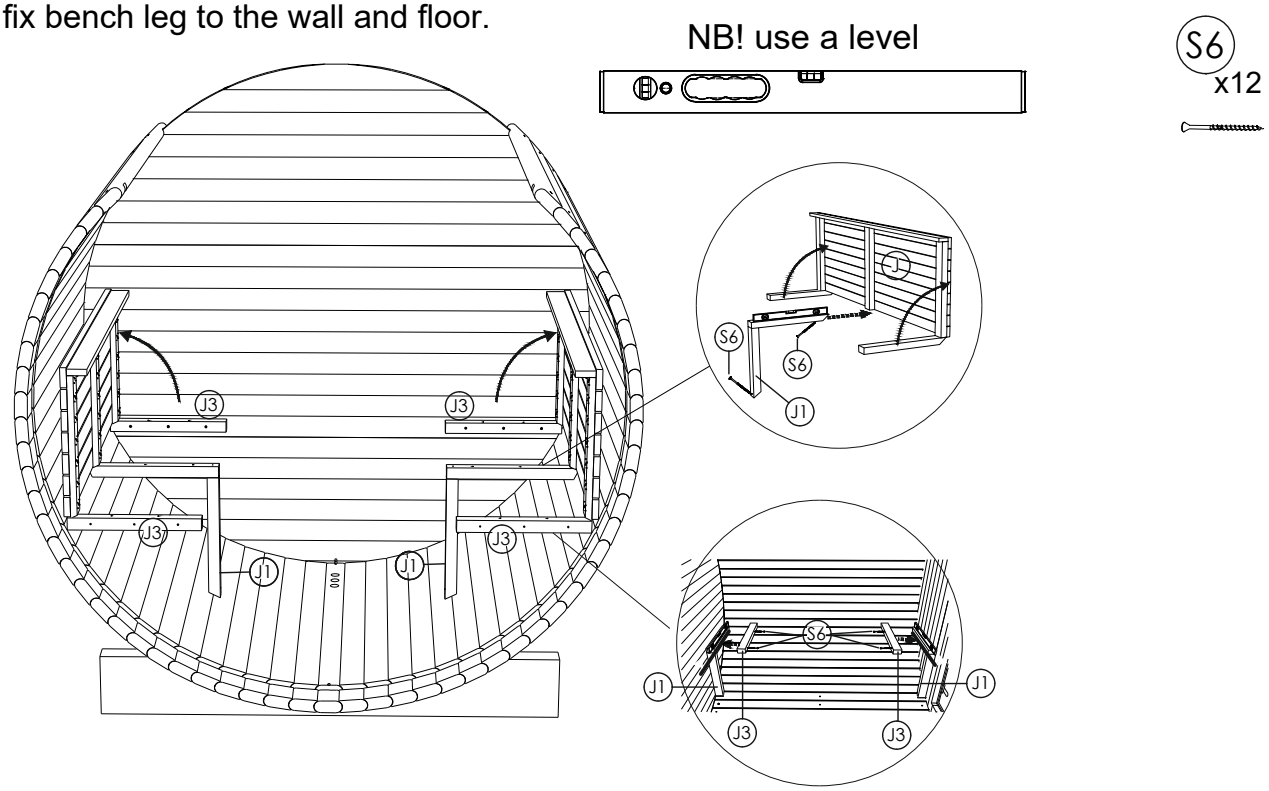
STEP 15: Put plastic spacers in the gap between the door box and the front panel where the screws go. Combine spacers for best width. First, fix one side of the door box with screws 5x80 (S14) through spacers. Then put spacers in other side. Combine spacers for necessary width. Spacers must fit tightly, they can't slip down before door is fixed with screws. Use screws 5x80 (S14) to fix doors. Check door box, both sides should be straight, they must not be bent inwards or outwards. Use foam around door box. Don't clean up the foam until it's dried out. The excess amount will come off easily if you don't touch it while it's wet.



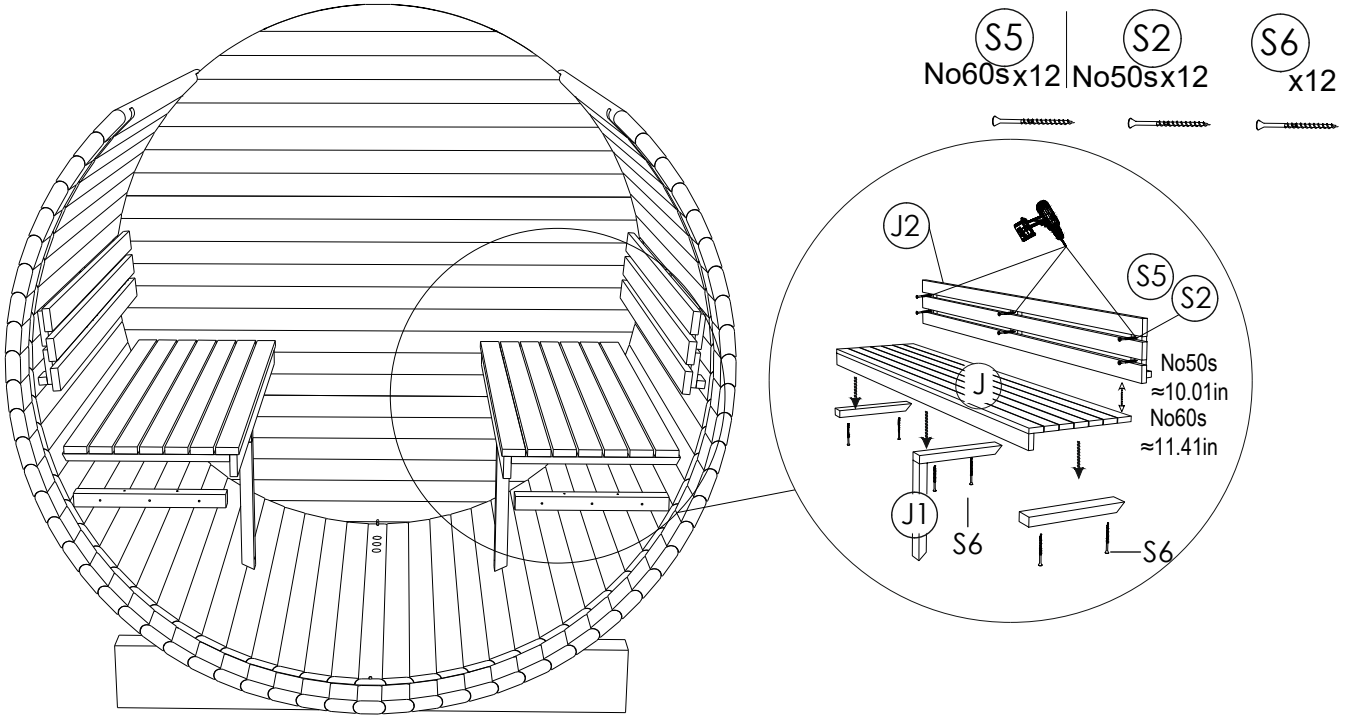
STEP 16: Fix door moldings to both sides and on top of the door with S5 screws 4x50ss.



STEP 17: To install wall mounts (J3) use interior supporting leg (J1). Put it on the sauna wall in level, mark a line where wall mounts will stand. Using screw 5.0x70 SS (S6) fix wall mounts (J3) on the marked lines. Install interior supporting leg (J1) in the center of bench (J). Stand bench on side wall mounts. Place J1 in the center and check the level. Using screw 5.0 x 70 SS (S6) fix bench leg to the wall and floor.



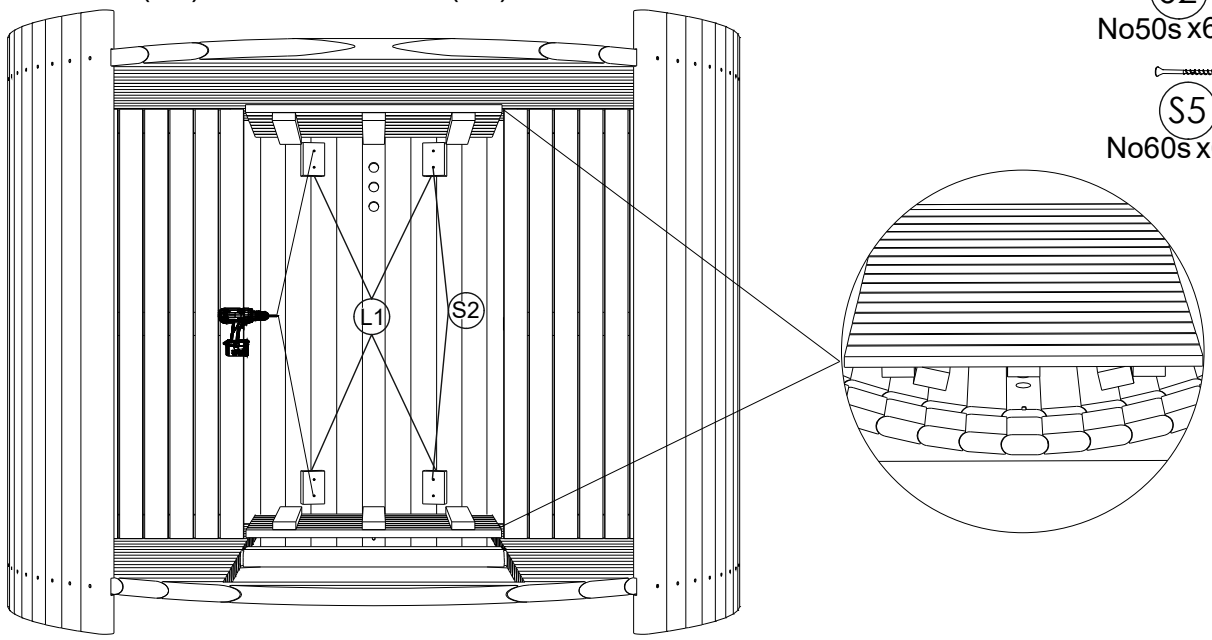
STEP 18: Pre-drill holes before fix backrest with screws, install backrests (J2) using screw 4.0 x 70 SS (S2). Fix sauna bench (J) to wall mounts and support leg using 5 x70 SS (S6) screws.



STEP 19: Place floor duckboards (L) to the both sides upwards and place fixing blocks next to the flooring cross boards. Pre-drill holes before fix with screws, install fixing blocks (L1) using screw 4.0 x 70 SS (S2)R190 or 4x50SS (S5)R225.

S2
No50s x6

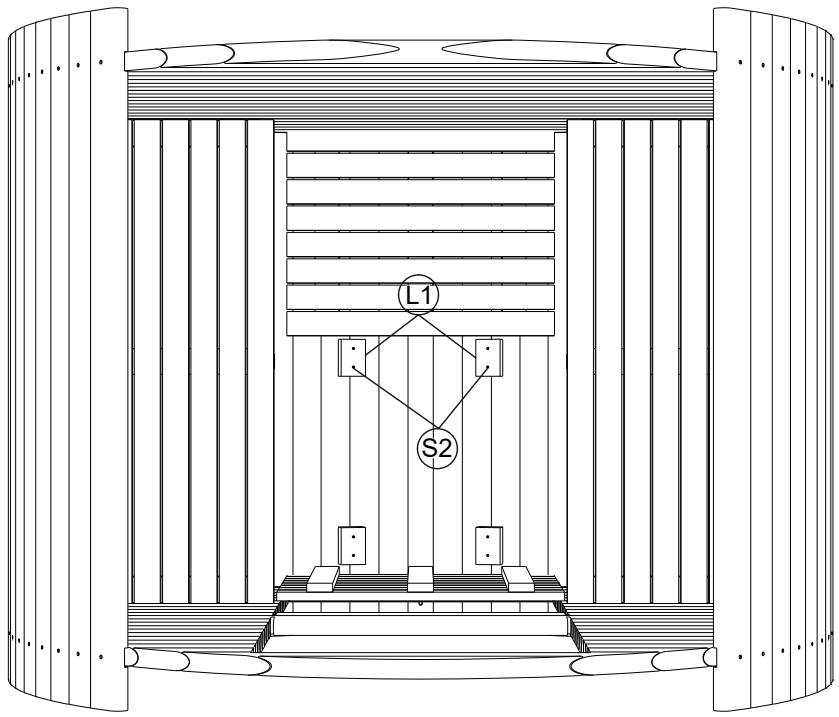
S5
No60s x6



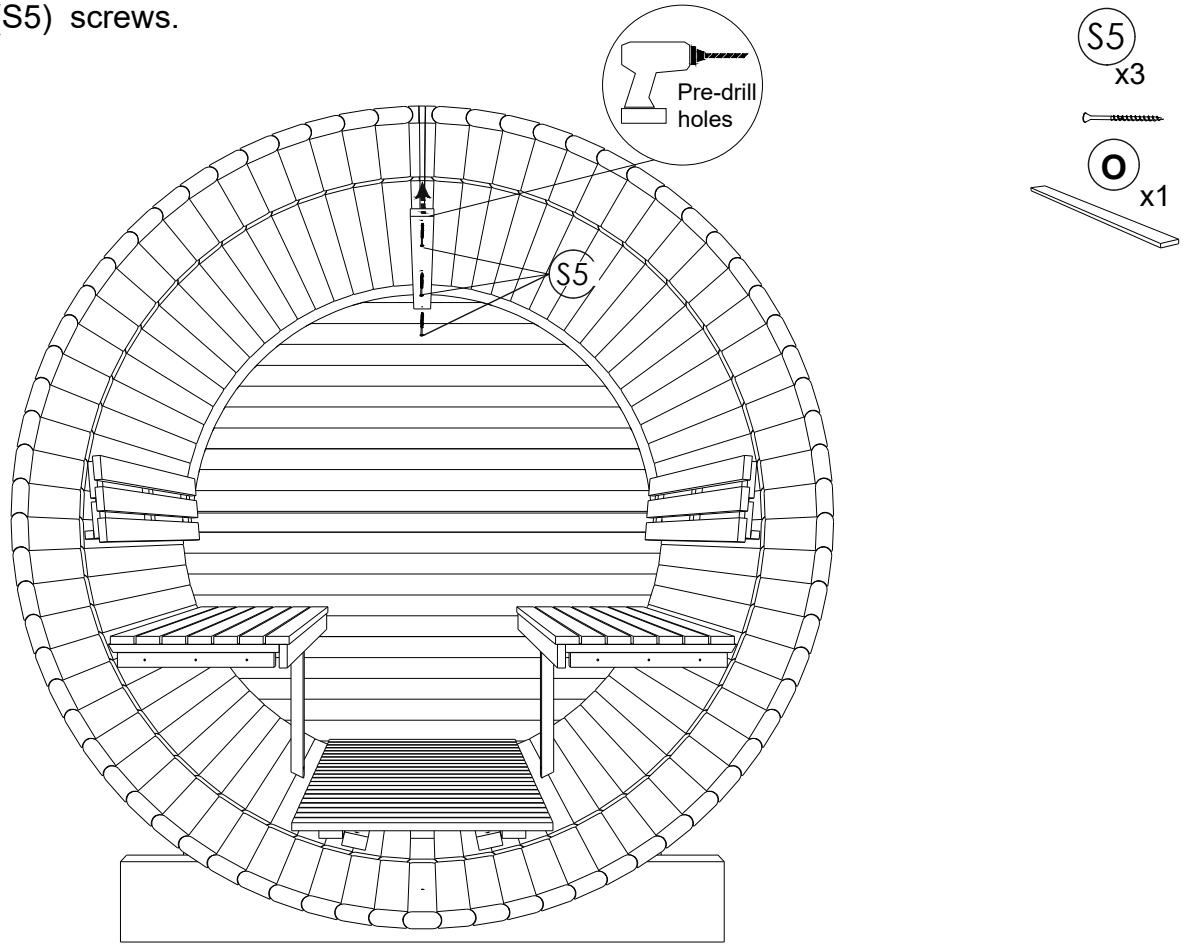
STEP 20: Pre-drill holes before fix with screws, install fixing blocks (L1) under floor duckboard using screw 4.0 x 70 SS (S2) R190 or 4x50SS (S5) R225. Place floor duckboards (L) on the floor and fix fixing blocks next to both flooring crossboards.

S2
No50s x4

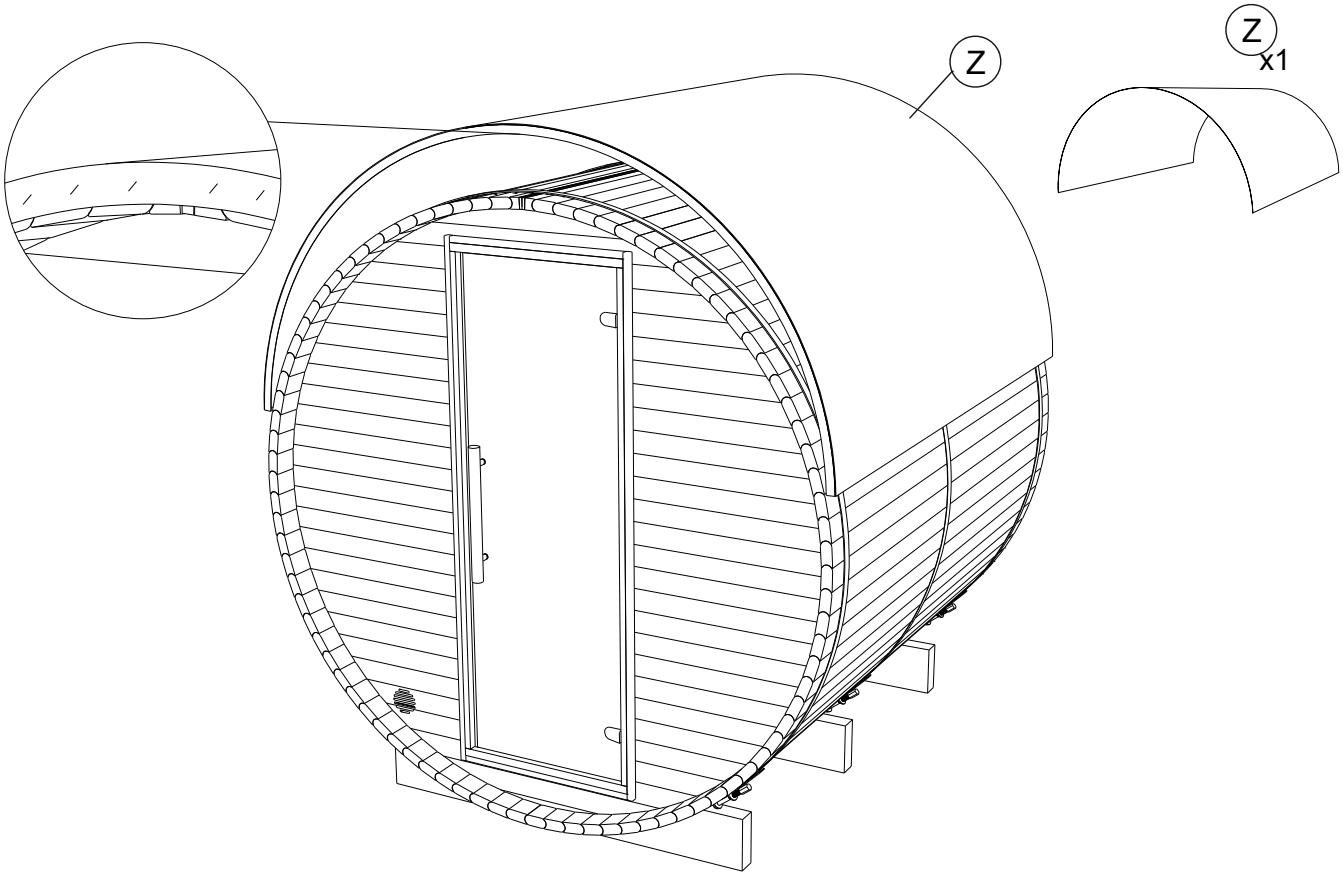
S5
No60s x4



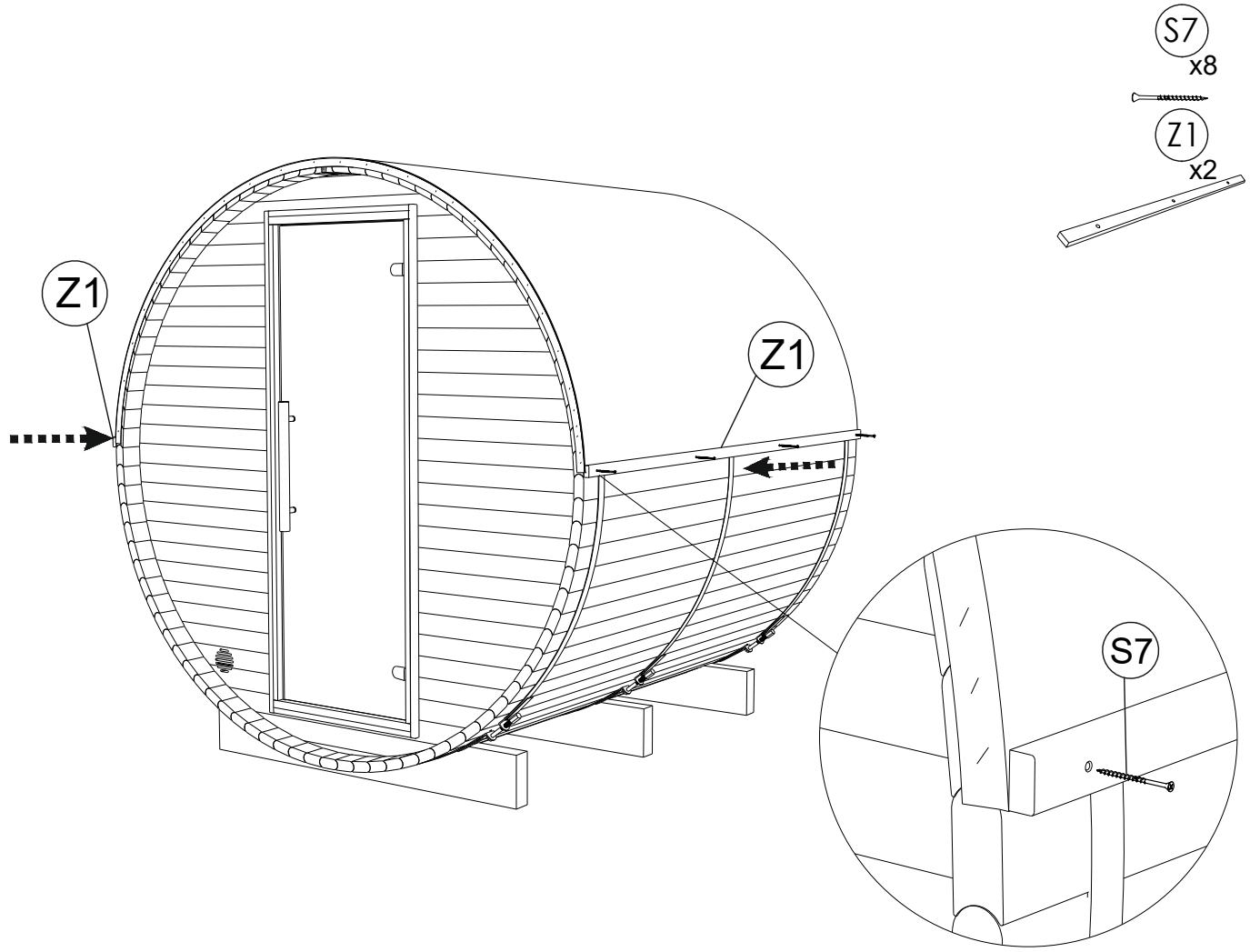
STEP 21: Pre-drill holes before fix stave with screws, install interior roof trim (O) in sauna with 4.0 x 50 SS (S5) screws.



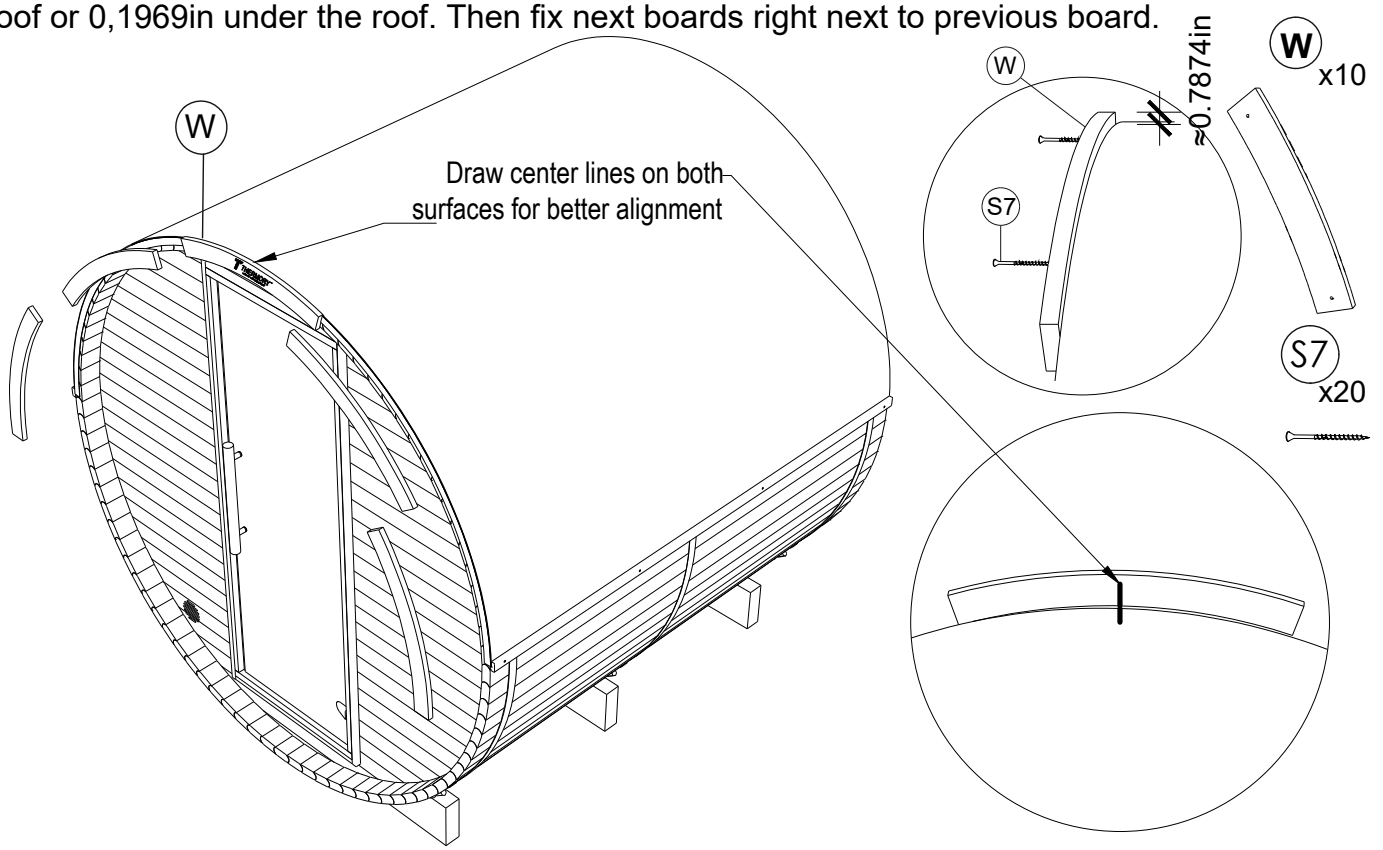
STEP 22: Place waterproof PVC roof cover . Align roof cover equally to both sides. Roof cover goes about 3cm over each sides edge. Staple roof cover on the saunas edge.



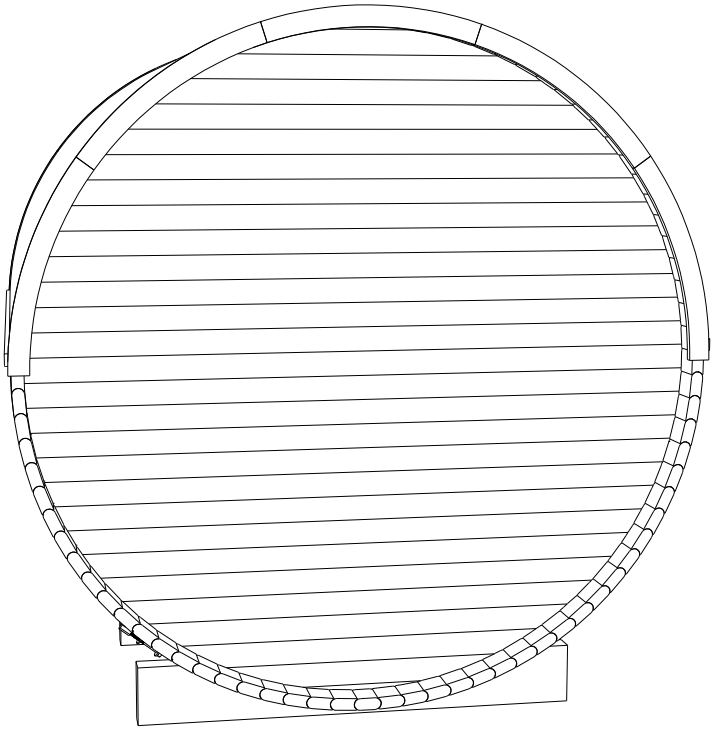
STEP 23: Fix with wooden slats (Z1) with screws 4.2x55 (S7) on the rain jacket bottom. The number of screws may vary depending on the sauna model.



STEP 24: Install front and rear decorative roof finishing boards (W), fixing by screws 4.2x55(S7). Start with a center board placing it at the top of the middle of the sauna, aprox.0,7874in above roof or 0,1969in under the roof. Then fix next boards right next to previous board.



STEP 25: Repeat step 24 to apply roof finishing boards at the back of the sauna roof edge.



IMPORTANT SAFETY INSTRUCTIONS

DANGER: Indicates a hazardous situation that, if not avoided, will result in death or serious injury.

WARNING: Indicates a hazardous situation that, if not avoided, could result in death or serious injury.

CAUTION: Indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

NOTICE: Indicates information considered important, but not hazard-related.

READ ALL INSTRUCTIONS BEFORE INSTALLATION AND USE TO AVOID INURY OR DAMAGE TO HEATER

FOLLOW SAFETY INFORMATION IN THIS DOCUMENT TO AVOID SERIOUS INJURY OR DEATH

REFER TO YOUR LOCAL BUILDING CODES FOR ANY SPECIFIC INSTALLATION REQUIREMENTS

ALL ELECTRICAL WORK NEEDS TO BE COMPLETED BY A LICENSED ELECTRICIAN. FAILURE TO DO SO COULD CAUSE INJURY OR DAMAGE TO THE HEATER.

MANUFACTURERS MANUAL TAKES PRECEDENCE OVER ANY DIRECTIONS LISTED IN THIS DOCUMENT

KEEP THESE INSTRUCTIONS FOR FUTURE REFERENCE

⚠ WARNING

• This appliance is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.

• Consult your doctor about any health-related limitations related to sauna use. Ignoring advice from your medical provider could cause serious injury or death.

• Do not let people with pre-existing health conditions bathe in the sauna on their own. Using the sauna could cause these users to lose consciousness.

• Parents should consult your pediatrician before allowing children to use the sauna. Ignoring advice from your medical provider could cause serious injury or death.

• Do not smoke, use alcohol, or exercise in the sauna. These tasks could cause users to lose consciousness.

• Do not exceed 30 min. in the sauna at one time, as excessive exposure may be harmful to health. The sauna should not be used as an endurance test.

• Do not place any combustible material over the sauna heater (towels, bathing suits, wooden bucket or ladle)! This will cause the sauna to catch fire.

• Hyperthermia occurs when the internal temperature of the body reaches a level several degrees above the normal body temperature of 98,6 °F. The symptoms of hyperthermia include an increase in the internal temperature of the body, dizziness, lethargy, drowsiness, and fainting.

• Do not sleep in a sauna in which the heater is operating. Sleeping in a heated sauna may lead to injury or death.

• Do not alter the heater in any way, unless explicitly instructed in this manual. Altering the heater could cause electrocution or fire risk.

• Only use stones approved for sauna heater use. Inadequate stones may crack or explode leading to serious injury.

⚠ CAUTION

• Keep all occupants away from the heater and when it is hot. The stones and outer surface of the heater may burn your skin.

• Do not throw excessive amounts of water on the stones. The evaporating water is boiling hot and could cause burns.

• Do not throw water directly onto the elements. This could cause burns and damage to the heater.

• Be very careful when moving in the sauna, as the benches and floors may be slippery. This could cause the user to slip and fall.